

# Work Order ID 71566

Wednesday, July 06, 2011 1:19:17 PM



Page 1

Item ID: D2804-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/6/2011 Start Qty: 6.00

Required Date: 7/22/2011 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: C2

Date: 11/07/06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2804

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-2 into arm as per Dwg D2804

SP 11/08/09 (5)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sulostko

(75)

2042

120

0.00



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:30AM OVEN TEMPERATURE:  
FINISH TIME: 10:00AM 320F

5 0 11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71566**

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Item ID: D2804-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5x J M 11/08/10

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Press Fit D2809 as per Dwg D2804

E 11/08/11 (5)

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 □2-Assemble as per Dwg D2804.

E 11/08/11 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 06, 2011 1:19:15 PM

Page 1

Work Order ID: 71566

Parent Item: D2804-042

Parent Item Name: Bracket Assembly



Start Date: 7/6/2011

Required Date: 7/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM  
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2  Bracket		Manufactured	No			100	Each	3.0000	1	6		7/11/08/09	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST149				3					
				46613				3					
D2805-2  Stop		Manufactured	No			100	Each	9.0000	1	6		7/11/08/09	
NAS1515H3  Washer		Purchased	No			100	Each	166.0000	4	24		7/11/08/11	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST277				166					
				116373				6					
				117460				60					
				118078				100					
AN3C16A  Bolt		Purchased	No			150	Each	57.0000	2	12		7/11/08/11	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST352				57					
				115835				17					
				118191				40					

B71877 (5x)

B71559 (5x)

20

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



# Picklist Print

Wednesday, July 06, 2011 1:19:15 PM

Work Order ID: 71566

Parent Item: D2804-042


Parent Item Name: Bracket Assembly

Start Date: 7/6/2011

Required Date: 7/22/2011

Start Qty: 6.00

Required Qty: 6.00

  
D2809  
Bushing

Manufactured No

150

Each

18.0000

1

6



*7/11/08/11*

Location

Loc Qty

Loc Code

ST

6

70805

6

ST023

12

34035

12

*B72735 (58)*

MS21043-3



Nut

Purchased

No

150

Each

1,119.000

2

12



*7/11/08/11*

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1047

112314

69

118077

978

*10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

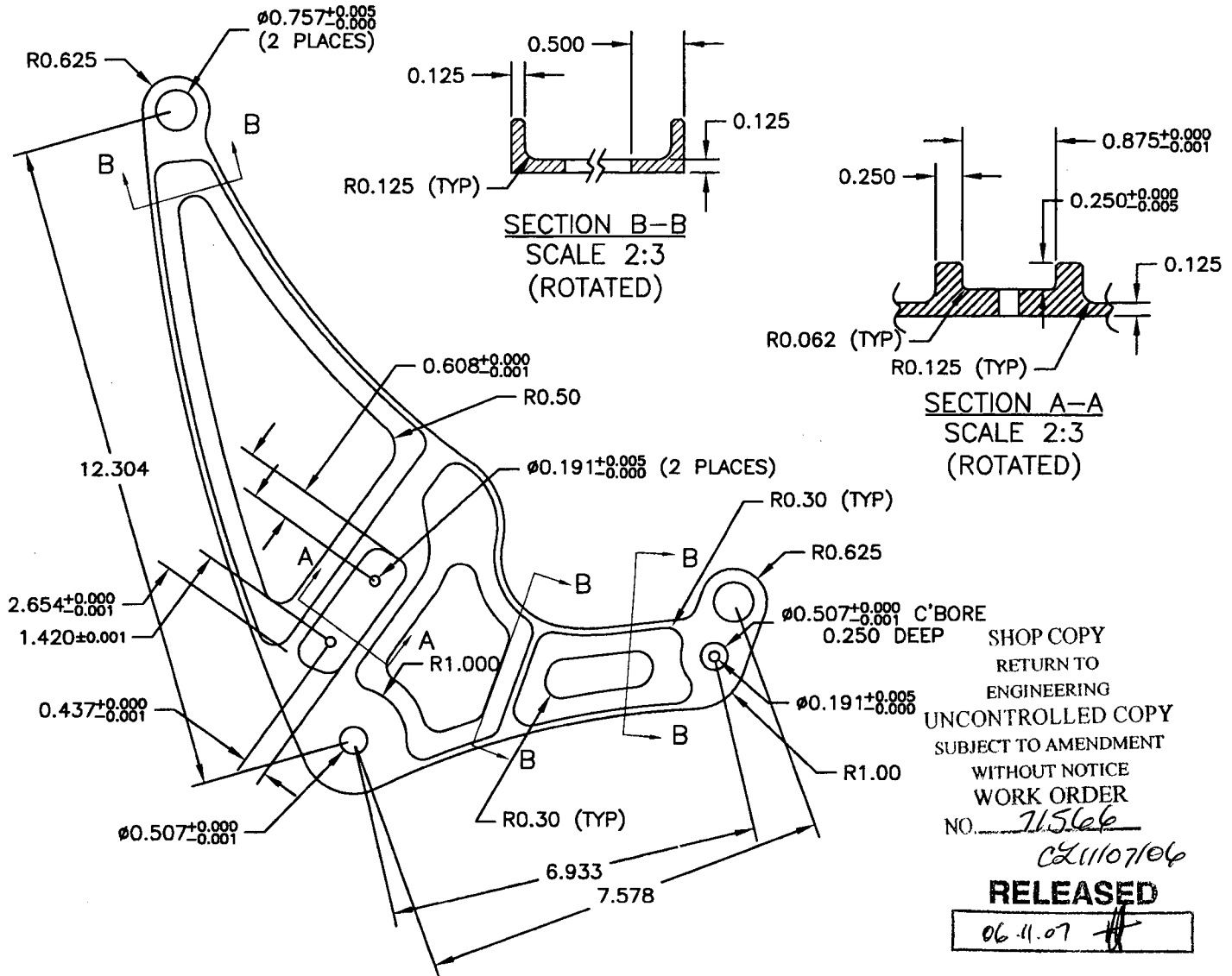
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16			TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	
C	06.10.16			CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

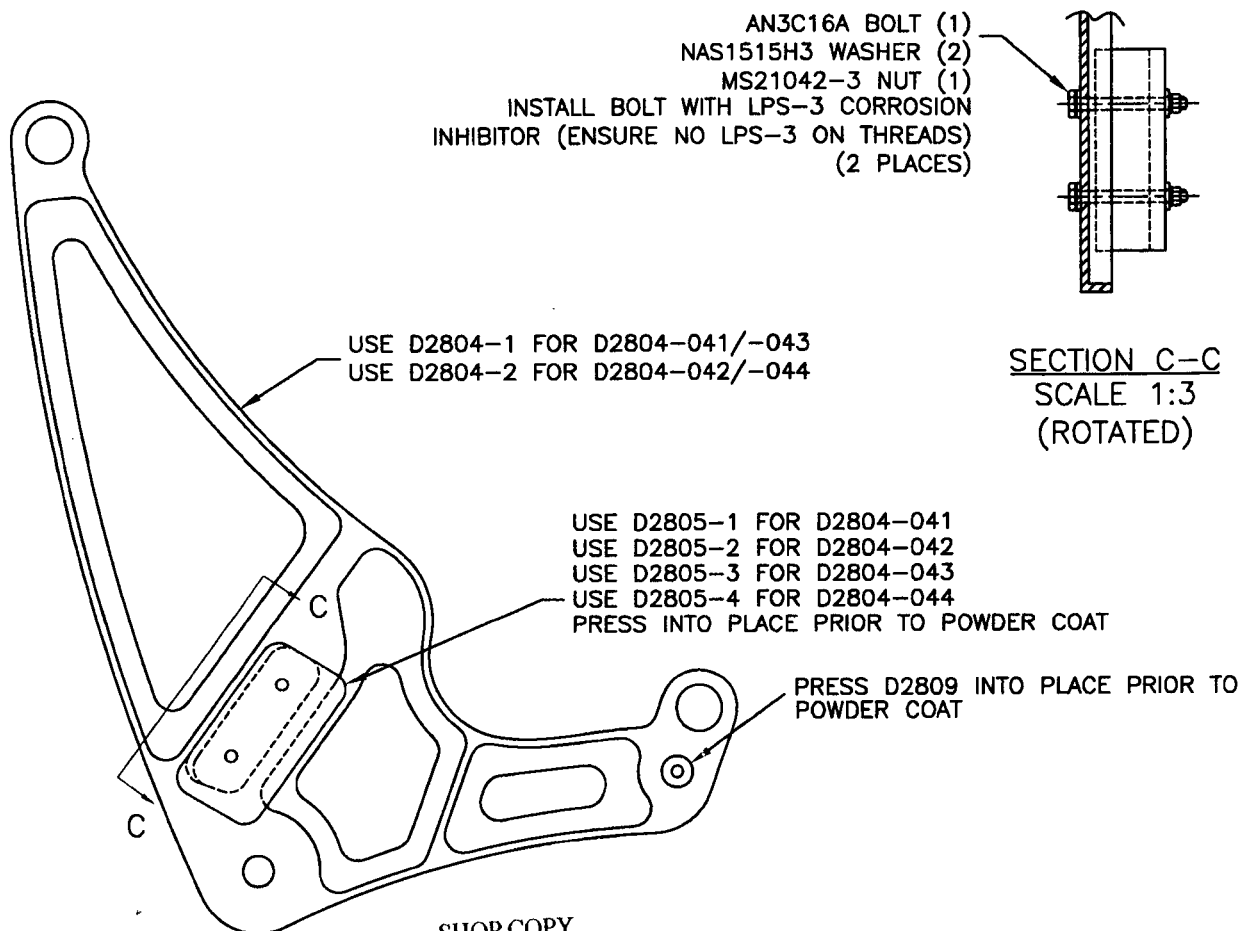
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C  
SCALE 1:3  
(ROTATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71566

WORK ORDER  
NO. 71566

RELEASED

06.11.07

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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